







FIG.5



Serial No. 10/083,896 Amdt. Dated October 22, 2003 REPLACEMENT SHEET(S)

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206 A DESIRED TOOLING PLATE IS SELECTED
A DESTREE TOOLING PEATE 13 SELECTED
CLAMPING BLOCK BOTTOM HALVES ARE POSITIONED ON TOOLING PLATE
248
CLAMPING BLOCK BOTTOM HALVES ARE CONNECTED TO TOOLING PLATE
224
TUBING IS CRADLED IN THE SADDLES AND CLAMPING BLOCK BOTTOM HALVES
230
CLAMPING BLOCK TOP HALVES ARE PLACED OVER TUBING AND COUPLED TO BOTTOM HALVES
242 [[]]]]]
BOTTOM HALVES ARE DECOUPLED FROM TOOLING PLATE WITH TUBING REMAINING CLAMPED
248
CLAMPING BLOCK IS COUPLED TO THE CUTTING MACHINE
254
TUBING IS CUT SUCH THAT DEBURRING IS NOT NEEDED
260
CLAMPING BLOCK DECOUPLED FROM CUTTING MACHINE WITH TUBING REMAINING CLAMPED
268
WELDING CASSETTE SECOND HALF IS PLACED IN AN OPEN POSITION
272
A CLAMPING BLOCK HOLDING TUBING IS PLACED ON EACH SIDE OF WELDING CASSET
278
CLOCKING SLOT OF EACH CLAMPING BLOCK IS MATED WITH A COCKING PIN
WELDING CASSETTE SECOND HALF IS PLACED IN THE CLOSED POSITION
WELDING HEAD AUTOGENEOUSLY WELDS TOGETHER THE TWO PIECE OF THIN-WALL TUBING